

DSAL

Dart Aerospace Ltd.

Date: Thursday, 17/07/2008 11:45:50 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPAD	
Job Number	: 40583-2			Split.	
Estimate Number	: 12784				
P.O. Number	:		Part Number	: D35649	
This Issue	: 17/07/2008	S.O. No. :	Drawing Number	: D3564 REV D	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: / /	Type : SMALL /MED FAB	Drawing Revision	: D	
Previous Run	: 39792		Material	:	
Written By	:		Due Date	: 31/07/2008 Qty: 12 Um: Each	
Checked & Approved By	: JUO 08.7.17				
Comment	Est Rev:A New Issue 07-03-08 ec Est Rev:B As per Rev C 07-07-09 JLM Est Rev:C As per Rev D 07-09-09 JLM Verified By:EC				

## Additional Product

~~POSSIBLE RECALL~~

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304S16GA	304/316 Sheet .063	
		MAT NOT PULLED	
		Comment: Qty.: 1.1550 sf(s)/Unit Total : 13.8600 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: 108724 HB 8-7-24	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3564 *****(D3564-1F)***** Dwg Rev: HB 8-7-24 Prog Rev:	
		2-Deburr if necessary HB 8-7-24	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE HB 8-7-24	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK S 08/07/25 +12	
5.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT 8129 and DT 8155 SB 08/07/25	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 17/07/2008 11:45:50 AM  
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Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: WEARPAD
Job Number: 40583		Part Number: D35649
Job Number:		
Seq. #:	Machine Or Operation:	Description :
Form Joggle as per Dwg D3564 on brake using Jig DT 8157		
6.0	QC5	INSPECT WORK TO CURRENT STEP  <i>EP 08/07/25 (2)</i>
Comment: INSPECT WORK TO CURRENT STEP Ensure joggle as per dwg D3429  <i>S 09/07/25 (4R)</i>		
7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1  <i>(A) EL 4-7-29. (P)</i>
Comment: LARGE FABRICATION RESOURCE 1 Qty Description Batch A/R 2059B Hardcoat <u>m108631</u> Weld hardcoat as per Dwg D3564		
8.0	QC10	VISUAL INSPECTION OF GROUND WELDS  <i>S 08/07/29 (8)</i>
Comment: VISUAL INSPECTION OF GROUND WELDS		
9.0	QC5	INSPECT WORK TO CURRENT STEP  <i>S 08/07/29 (8)</i>
Comment: INSPECT WORK TO CURRENT STEP		
10.0	POWDER COATING	POWDER COATING  <i>M 106442 (9X)</i>
Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 START TIME: <u>3:15pm</u> OVEN TEMPERATURE: <u>320°f</u> FINISH TIME: <u>3:45</u> <i>m.f 08/07/29</i>		
11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION  <i>FZ 08/07/29 (9)</i>
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		
12.0	PACKAGING 1	PACKAGING RESOURCE #1  <i>(9X)</i>
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>F-P 19</u> <i>m.f 08/07/30</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 17/07/2008 11:45:50 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 40583

Part Number: D35649

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/31 A

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-07-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action      Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	40583
Description: Wearshoe	Part Number:	D3564-9
Inspection Dwg: D3564	Rev: D	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	<u>FB</u>	Audited by:	<u>J</u>	Prototype Approval:	N/A
Date:	8-7-24	Date:	08/07/25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/EC/DD	

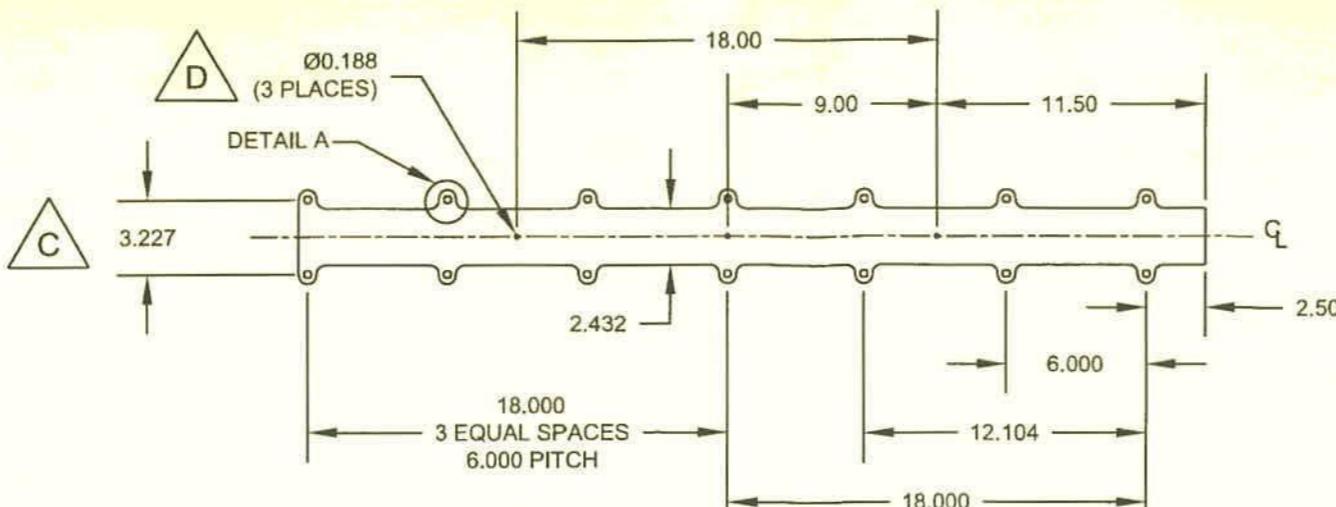
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action      Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

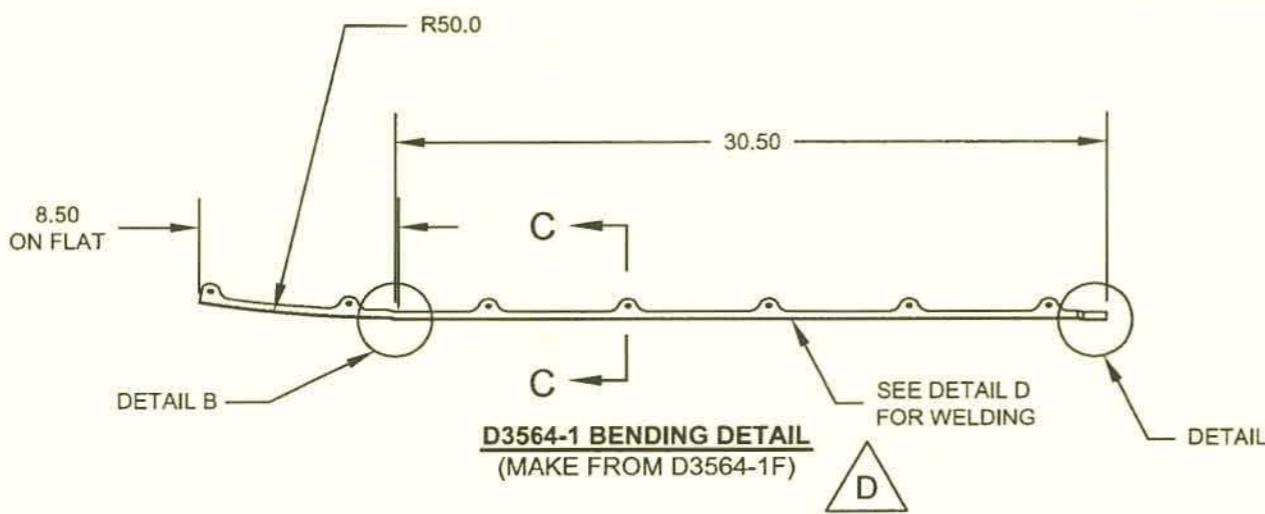
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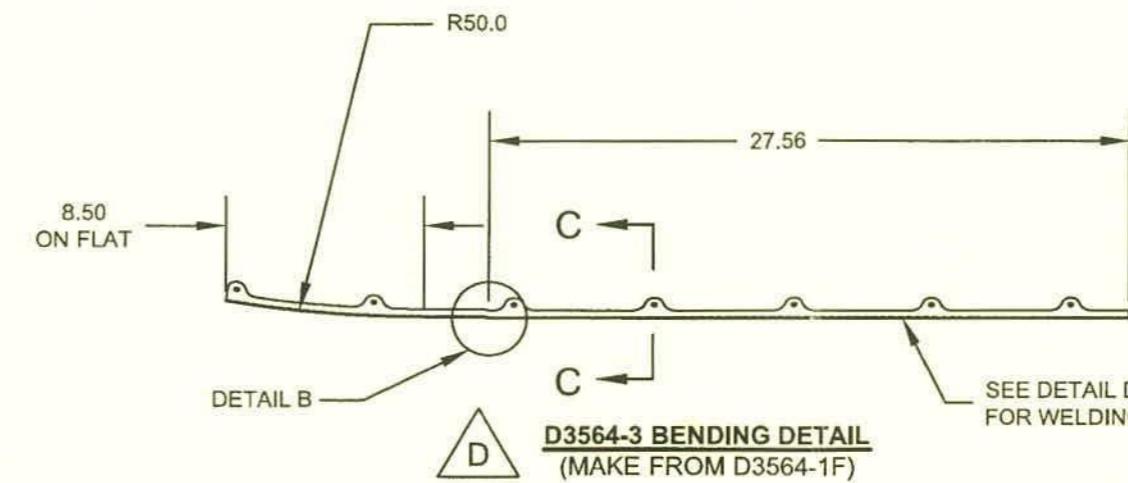
D3564-1F FLAT PATTERN

RELEASED

07.09.04



D3564-1 BENDING DETAIL  
(MAKE FROM D3564-1F)



D3564-3 BENDING DETAIL  
(MAKE FROM D3564-1F)

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WITHOUT NOTICE  
WORK ORDER  
NO. 40583

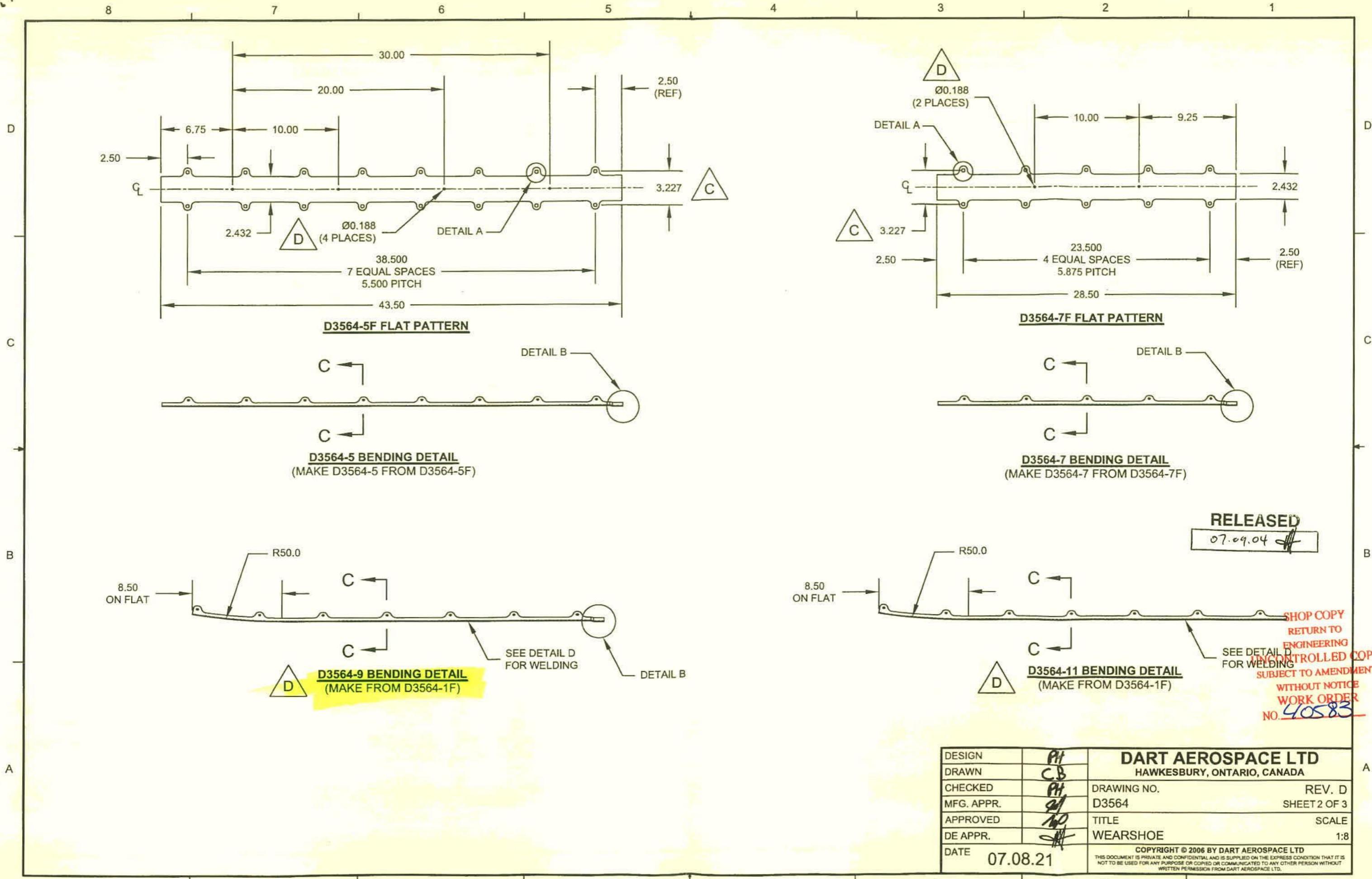
**D3564-1/3-5/7-9-11-13-15 WEARPLATE NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT  $\frac{1}{2}$

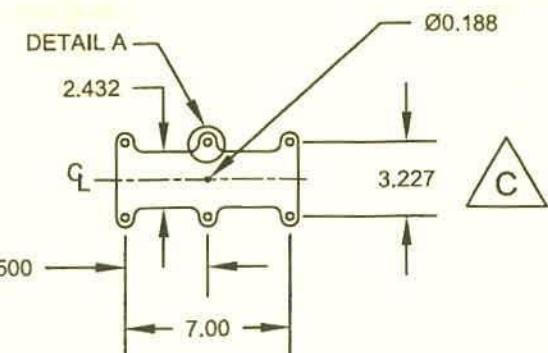
WEIGHTS:  
 D3564-1 1.85 lbs  
 D3564-3 1.85 lbs  
 D3564-5 1.93 lbs  
 D3564-7 1.26 lbs  
 D3564-9 1.85 lbs  
 D3564-11 1.85 lbs  
 D3564-13 0.38 lbs  
 D3564-15 0.80 lbs

REV.	DESCRIPTION	BY	DATE
D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
DESIGN	P1	<b>DART AEROSPACE LTD</b>	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	P1	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 1 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

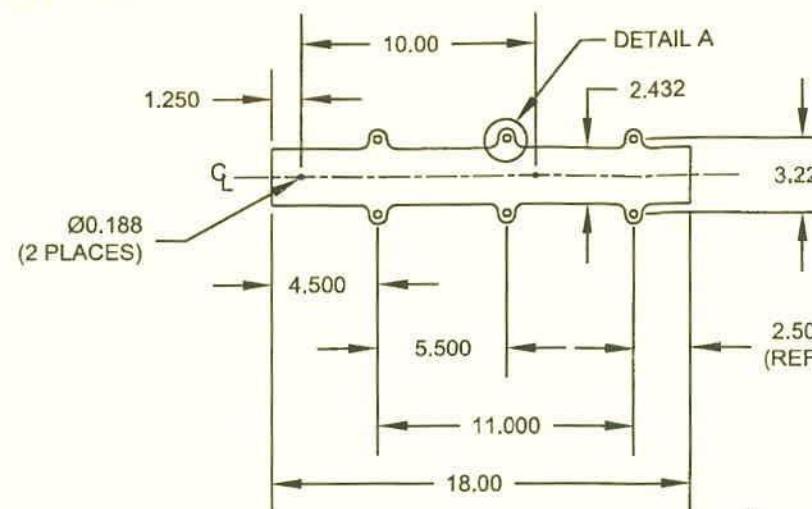




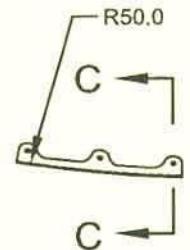




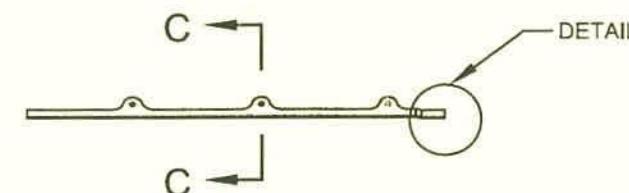
D3564-13F FLAT PATTERN



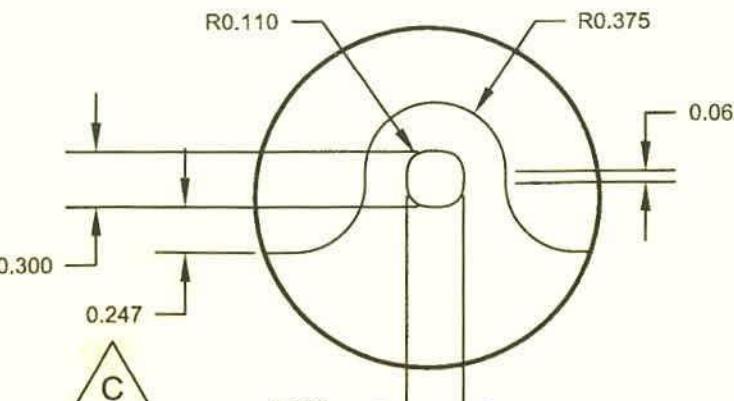
D3564-15F FLAT PATTERN



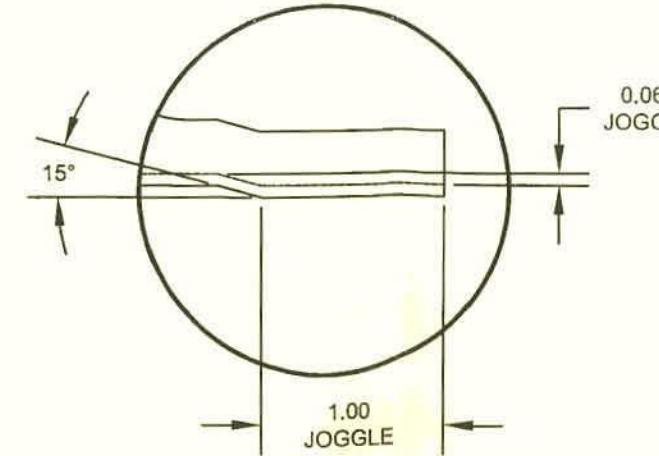
D3564-13 BENDING DETAIL  
(MAKE D3564-13 FROM D3564-13F)



D3564-15 BENDING DETAIL  
(MAKE D3564-15 FROM D3564-15F)

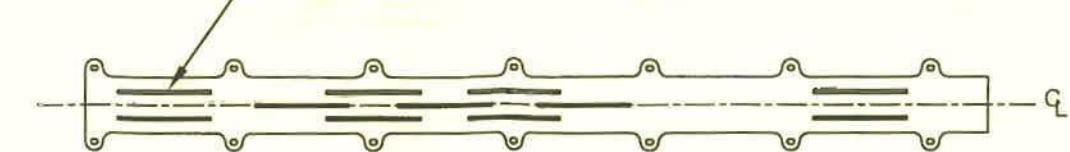


DETAIL A  
SCALE 1:1



DETAIL B  
SCALE 1:1

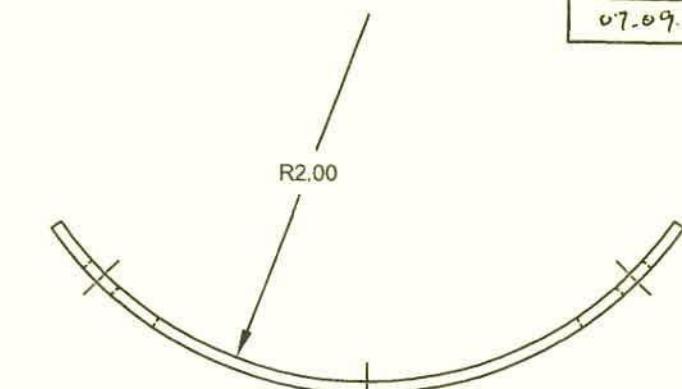
2059B HARDCOAT WELD 4.0 LONG 0.063 TO 0.125 HIGH  
(11 PLACES)  
WELD AFTER BENDING AS ILLUSTRATED PER DT8308



DETAIL D  
(D3564-1/3-9-11 WELDING DETAIL)

**RELEASED**

07.09.04



SECTION C-C  
SCALE 1:1

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WORK ORDER  
NO. 40583

DESIGN	<i>PH</i>	DART AEROSPACE LTD	
DRAWN	<i>CB</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	
MFG. APPR.	<i>SH</i>	D3564	REV. D
APPROVED	<i>SH</i>	TITLE	SHEET 3 OF 3
DE APPR.	<i>SH</i>	WEARSHOE	SCALE
DATE	07.08.21		1:8

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